

538

DART AEROSPACE LTD	Work Order:	24002
Description: Contoured Detent Clip Base	Part Number:	D3440-5
Dwg: D3440 Rev. A page 3	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AP	05/08/12	20
2	MV	Cut blank: 1.250" x 1.250" x 2.000" long Material: 6061-T6 Bar 1.250" x 1.250" (M6061T6B1.250x01.250) Identify for D3440-5			
		Batch: M11944 M11972	BG	05.08.22	20
3	MV	Machine as per Folio FA536 and Dwg D3440 Dwg Rev: A Identify as D3440-5	BG	05.08.27	20
4	QC2	Inspect parts as they come off the CNC machine	BG	05.08.27	20
5	QC8	Second check	TM	05/08/30	20
6	MV	Deburr	BG	05.08.27	20
7	ST	Identify and Stock	CL	05/08/30	20
8	AC	Cost / part: 10.31	S45	05.08.31	20
9	DC	Close W/O. 14,56 Inspect Level 21	EB	05/08/31	20

Rev	Date	Change	Revised By	Approved
A	05.06.30	New issue	KJ/JLM	

RELEASED
05/06/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 05.08.31

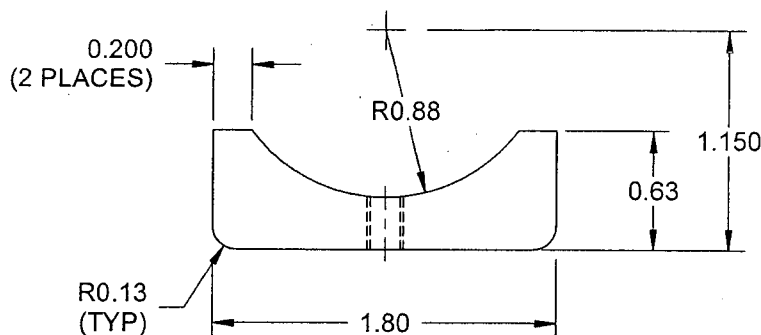
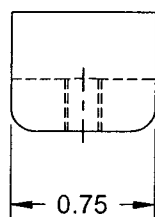
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

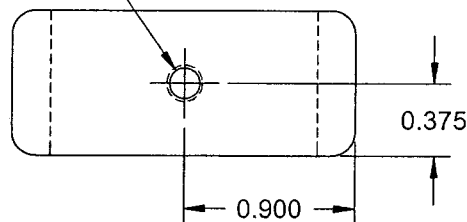


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3440	REV. A SHEET 3 OF 7
DATE 05.06.02		TITLE BLADE FOLD KIT PARTS SCALE 1:1	

RELEASED
[Signature]
05/08/18



DRILL $\varnothing 0.159$ THRU,
TAP #10-32 UNF THRU



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24002

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
11:26 am

Work Order No	: 0024002	Department Code:	
Project Name	: D3440-5	Burden Flags	: NNNNNNNN
Project For	: WK538	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3440-5	Invoice Number	:
Description	: Contoured DetentClipBase	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-09-05		
Est Finish Date	: 09-28-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

